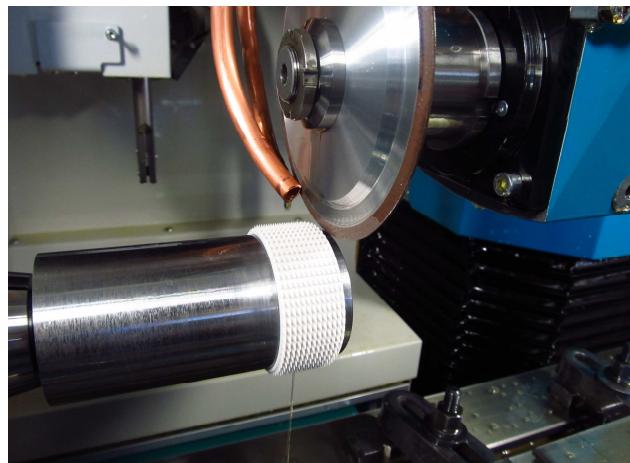
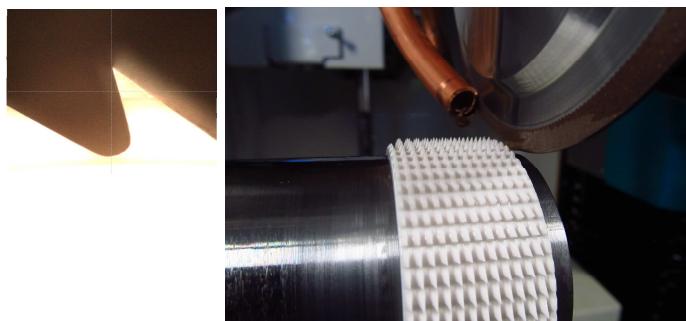


Ceramic Ring Ø64Z55P2

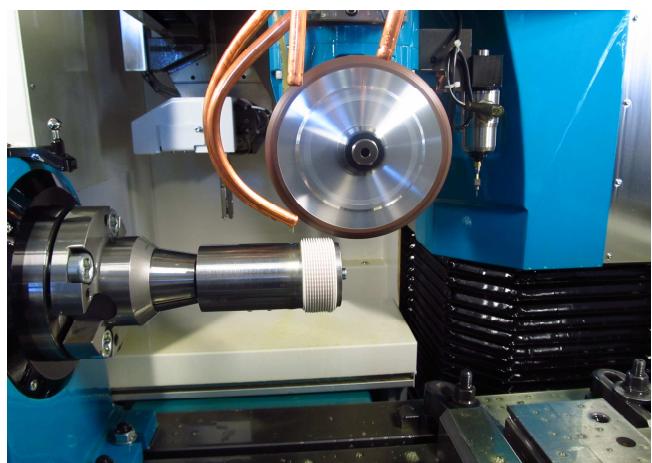
A30-200

The ceramic ring is ground in to process: a first process with form wheel to obtain the 2 mm thread. A second process generates the teeth when grinding the 55 flutes. The ceramic ring are made of, is sensitive to temperature. Cooling with emulsion is necessary..



1. Cycletime for Production

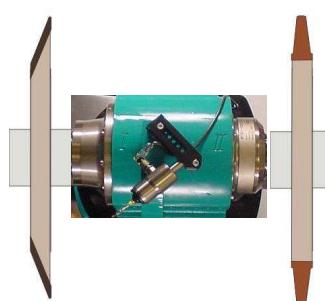
Workpiece:	Ø 64 mm, Z 55, L 27 mm, Helix 2 mm Material CERAMIC		
Operations	Profile	Flute	Prf.Fin.
Feed [mm/Min]	180	170	1200
Power [kW]	1	2	1
Cutting speed [m/s]	12	12	12
Used wheels			
Grinding time [s]	1805	972	211
Total cycle time	49 Min 48		



The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	DXF Ø125-175 D126
2	1V1 Ø125-175 D126



2

1

3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG

Control: Fanuc 31iA5

Accessories:

Responsible engineer: OP. 17.9.12

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J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, UK, China

Coolant: Synthetic Emulsion, pressure 6 bar

Software: Quinto 5

TECHNOLOGY
FOR TOOLING